

Date: Wednesday, 06/09/2006 11:05:29 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	28426		
Estimate Number :	12524		
P.O. Number :		Part Number :	D35341
This Issue :	06/09/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	UNDER REVIEW <i>E 0609.05</i>
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	N/A
Written By :	<i>E</i>	Material :	N/A
Checked & Approved By :		Due Date :	13/09/2006
Comment :	Est Rev:A New Issue 06-09.06 EC		

Qty: 2 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2048 sf(s)/Unit Total : 0.4095 sf(s)

2024-T3-.050 sheet

Batch: *MT9053*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3534

Dwg Rev: *Preliminary*

Prog Rev: *Preliminary*

MM 06 09 06

(2)

2-Deburr if necessary

MM 06 09 06

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM

06 09 02

(2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

E 06.09.06

(2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

E 06 09 06

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:30 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28426

Part Number: D35341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 06-09-07

②

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 06-09-17

②

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

for eng. use only

E 06-09-19

②

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

07/03/08

②

Job Completion



06-09-20

Eng Approval

CB 07.03.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

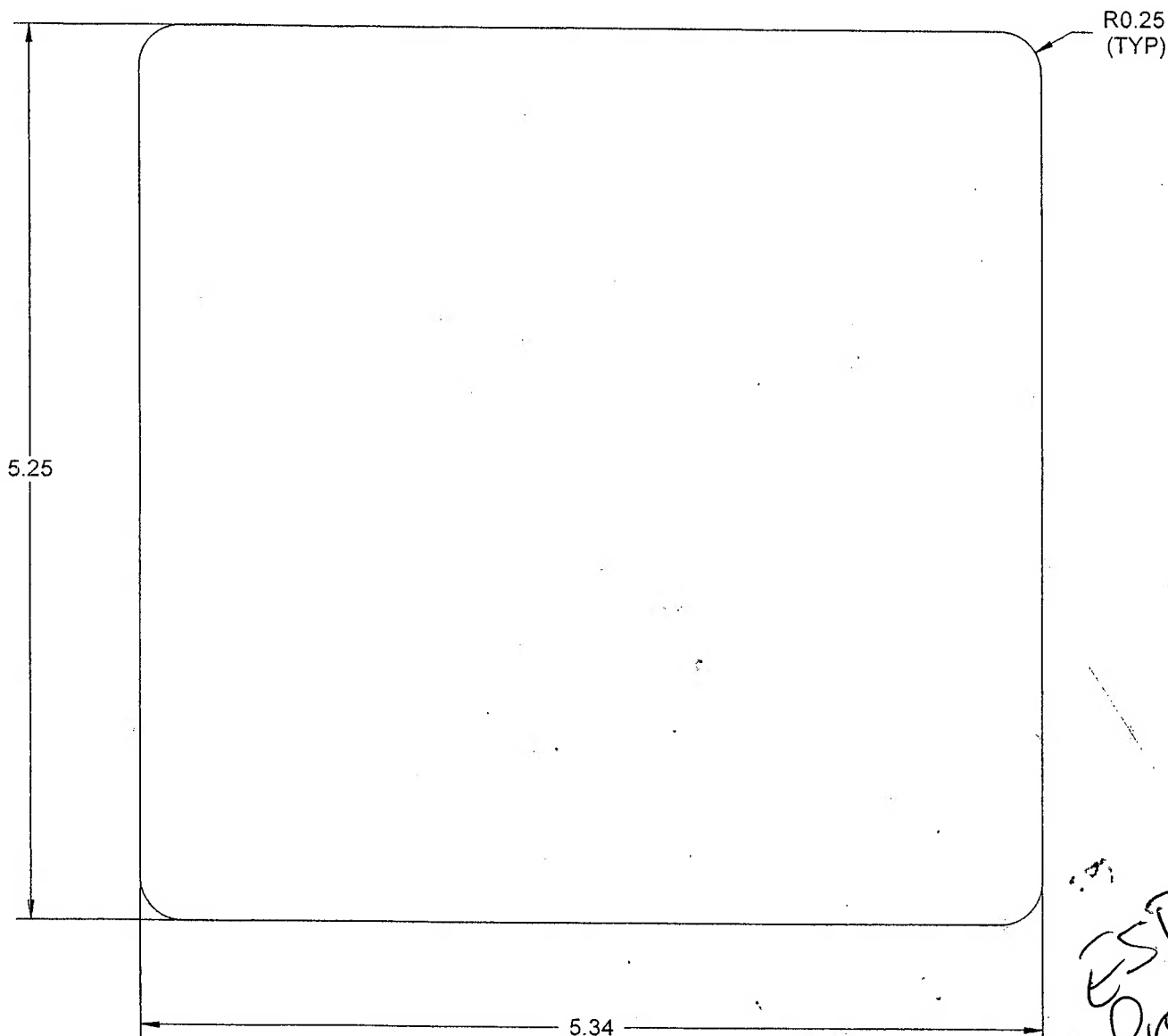
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3534	REV. A SHEET 1 OF 1
DATE 06.07.14		TITLE DOUBLER	SCALE 1:1
A	06.07.14	NEW ISSUE	



D3534-1 DOUBLER

UNDER REVIEW

06.08.22 CB

prototype

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050" THICK (QQ-A-250/5 OR AMS 4037)
(REF DART SPEC M2024T3S.050)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS
Ship From: RIVERDALE, IA.

Page 1

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrablic

Mark J. Vrablic
Director of Manufacturing Development Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

391671 101057
Ship Date B.L. No.
2005-04-12 73600
P.O. No./Govt Contract No. Customer
M17105 SAMUEL SON-MISSISS

Ship To: SAMUEL, SON & CO. LIMITED,
2360 DIXIE ROAD,
MISSISSAUGA, ON. L4Y 1Z7

Item Description
1050 IN TK X 48 IN W (N) A/T 2024-T3 COILED SHEET MILL FINISH. PER AMS-QQ-
A-250/4 REV A PER AMS4037 REV N PER
ASTM B209 REV 04 ((NOT MARKED)) COIL SIZES:
1D-20 IN COIL WGT: MAX 4500 LB PKG WGT: 5000
LB EXPORT PACK QUAN TOL +/-40 %
CQR 0155764 REV 01 CUST REQ 05-04-
02 *** W/E 05-04-16 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	275909	347531	3071	1	PC	0404193
2	275910	347531	3941	1	PC	0404194
			7012	2		

Notes for CQR: 0155764.1
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: 0155764.1 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT	Other	Other
T3	Long Transv.			63.0	42.0	15		

Chemical Composition

	SI	FR	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
Alloy 2024	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15
	Min			3.8	.30	1.2					REMAIN

Lot: 347531 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T3	Long Transv.	2	Max	Min	67.9	47	18.5
					67.8	46.1	17.4

M17105-3

Allen Q. Dept

Date	11-14-05
Cust	Port
W/O #	172854
Qty.	70 Pcs. 2
<input checked="" type="checkbox"/> Size	<input type="checkbox"/> Special Instructions
<input type="checkbox"/> Part #	<input type="checkbox"/> Alloy <input type="checkbox"/> Heat
These test reports are for on your PO# 100000008	
From Copper	
<i>LaShan Ourham</i> Quality Representative	
Customer Part #	